

TECOLINE F

Door Rebate edging

Characteristics:

TECOLINE F is an endless single-layer edging, in door rebate quality, supplied in rolls with a surface finish. Made from non-fading, specially-formulated papers, in plain colours or printed with woodgrain or fancy patterns and impregnated with duroplastic resins.

Types:

TECOLINE F 50 Thickness approx. 0.28 - 0.31 mm

Applications: Edging for door rebates

Substrates: Particle board, MDF board, solid wood, etc.

Processing: TECOLINE F edges are specially designed for processing on door rebate lamination lines where the glue is applied on the backside of the edge. They are characterized by a high flexibility and good forming properties when heated up. Infeed and temperatures depend on the profile and glue type.

For processing on an edgebanding machine where the glue is applied on the side of the workpiece, edges from our TECOLINE P or TECOLINE S range should be used. Alternatively we could recommend the use of TECOLINE F edges with primer pregling on the backside.

Example: EVA hot melt adhesive

Wood moisture content: approx. 8-12 %

Feed rate: approx. 25 m/min.

Glue temperature: approx. 200 °C

Hot air temperature: approx. 500 °C

Please follow the instruction of the machine and glue manufacturers.

The temperature of the material being processed should not be less than 20 °C.

Finish: Lacquered finish in various designs and gloss levels.

For the full range of options please refer to our product brochure entitled "Finish designs".

Embossing:

- Mechanical woodgrain pore
- Mechanical ash pore
- Chemical woodgrain pore (real pore)
- Pearl structure

Chemical resistance: Depending on the surface finish TECOLINE S edging strips are chemically resistant as defined by DIN 68861, Part 1B to 1D.

Fastness to light: At least 6 on the international wool scale, DIN EN ISO 105-B02

Backings:	Reverse sanding: For special processing techniques (e.g. PVAc adhesive bonding)
	PVAc glue: Pre-coated edges for thermo activation process
	Primer: Polyurethan primer for improved bonding of our products when using ordinary hotmelt glues.
	Hotmelt-coating: EVA hot melt adhesives (normal and heat-resistant) and polyamide hot melt adhesives for industry, skilled trade and DIY.
Form as supplied:	Roll widths: 15 mm - 100 mm Special widths available on request
	Hot melt pre-coating: optionally
	Internal roll diameter: 150 mm
	Roll length: without hot melt adhesive approx. 450 m with hot melt adhesive approx. 200 m
Packaging:	In polyethylene bags in boxes on pallets.
Storage:	6 months, cool and dry in original packaging (approx. 20 °C, 55-65 % air humidity).

The information provided in this specification is based on actual practice and on the results of in-house testing and is consistent with the current level of our knowledge. This information is intended merely as a guide and shall not be deemed to provide any warranty of specific product properties or suitability for a specific application. Since we have no influence on materials and processing conditions, we cannot be held liable for anything arising from this specification.

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